

SPLIT - 1

Work Order ID 117027-1

\*117027\*

Page 1

June-09-14 2:31:23 PM

Item ID: D4095-043 Accept \*N9000040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Wearplate Assembly  
Start Date: 4/23/14 Start Qty: 12.00 \*12\* Cust Item ID:  
Required Date: 4/23/14 Req'd Qty: 12.00 \*12\* Customer:  
Reference:

Approvals: Process Plan: A Date: Tooling: Date: Run Start \*NR1\*  
QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4095	B

105 0.00

\*105\*

Purchasing

Memo

Purchasing

ISSUE PO 24577  
CUT PER DRWG D4095 REV.B

115 Receive & Inspect for Damage & Mat'l Certs 0.00

\*115\*

Packaging

Memo

Packaging

125 QC6- Inspect dimensions to drawing 0.00

\*125\*

QC

Memo

Quality Control

DAS  
27  
9/89  
1477

C2 14/06/12 12

Pu 14/7/4 (12)

10

# Work Order ID 117027

June-09-14 2:31:23 PM

**\*117027\***

Page 2

Item ID: D4095-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 4/23/14 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 4/23/14 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	NC BRAKE								
Brake NC	Memo	0.00			DAS				
Brake NC	1- bend section C-C first				30				
	2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155				9-89				
	3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control	Ensure joggle as per dwg D4095								
150		0.00							
<b>*150*</b>	Weld per dwg A/R Hardcoat S.S. Batch: <u>M130712</u>								
Large Fab	Large Fab	0.00							
Large Fab	Memo								

14/07/14

5/14/14

12

6

14-10-30 MAL/EE

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Page 3

[illegible]



Work Order ID 117027

June-09-14 2:31:23 PM

\*117027\*

Page 4

Item ID: D4095-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate Assembly  
 Start Date: 4/23/14 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 4/23/14 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC3- Inspect Part Finish	0.00							DAS 38 9-89
*190*									
QC	Memo	0.00							
Quality Control									

NOV 07 2014

200	Identify as per dwg & Stock Location: <u>FP-607</u>	0.00							
*200*									
Packaging	Memo	0.00							
Packaging									

X 6 of 11/10/07

210	QC21- Final Inspection - Work Order Release	0.00							
*210*									
QC	Memo	0.00							
Quality Control									

14/11/10

AP4-11-07

# Picklist Print

Juna-09-14 2:31:22 PM

Page 1

Work Order ID: 117027

\*117027\*

Parent Item: D4095-043

\*D4095-043\*

Parent Item Name: Wearplate Assembly

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	144.8670	2.275	29			

\*M304S16GA\*

\*\*

C214/06/19

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

144.867

M127821

75.567

M128423

1.2

M129192

68.1

m129545

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	117027
<b>Description:</b> Wearplate		<b>Part Number:</b>	D4095-3
<b>Inspection Dwg:</b> D4095	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

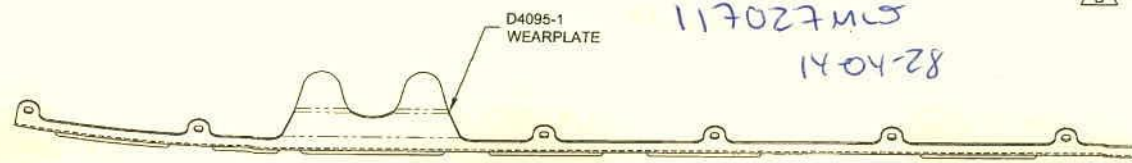
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190"	-		✓	Jhm01
0.300	+/-0.010	0.295"	-		✓	
0.300	+/-0.010	0.294"	-		✓	
2.432	+/-0.010	2.432"	-		✓	
3.227	+/-0.010	3.227"	-		✓	
4.06	+/-0.030	4.06"	-		✓	
2.50	+/-0.030	2.50"	-		✓	
4.98	+/-0.030	4.98"	-		✓	
8.43	+/-0.030	8.43"	-		✓	Jhm00
11.50	+/-0.030	11.50"	-		T	Jhm07
21.750	+/-0.010	21.750"	-		T	
3.500	+/-0.010	3.500"	-		✓	
12.22	+/-0.030	12.22"	-		T	
6.000	+/-0.010	6.003"	-		✓	
12.100	+/-0.010	12.100"	-		T	
21.00	+/-0.030	21.00"	-		T	
30.000	+/-0.010	30.000"	-		T	
36.000	+/-0.010	36.000"	-		T	
38.88	+/-0.030	38.88"	-		T	
0.063	+/-0.010	0.058"	-		✓	

<b>Measured by:</b>	DAS 23 9-89	<b>Audited by:</b>	DAS 27 9-89	<b>Preliminary Approval:</b>	
<b>Date:</b>	14-07-7.	<b>Date:</b>	14/7/7	<b>Date:</b>	

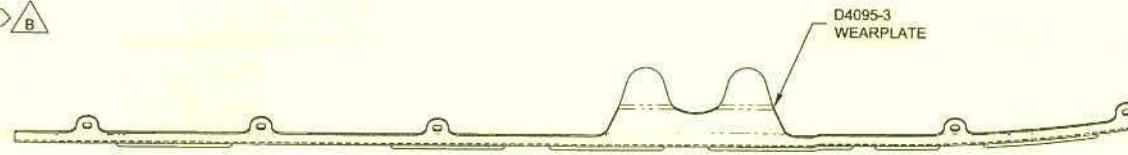
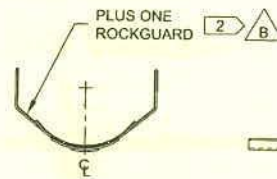
Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	



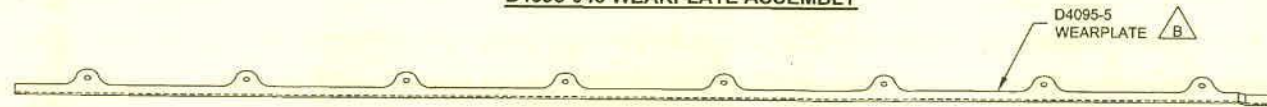
ITEM	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



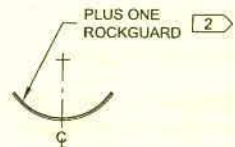
**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**



**D4095-045 WEARPLATE ASSEMBLY**



**D4095-041/-043/-045/-047/-049/-051 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1A-1F/3/3F: 4715 PLUS ONE ROCKGUARD REPLACES D4095-1A-1/3; ADDED D4095-5/7-9/11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	11.10.18		

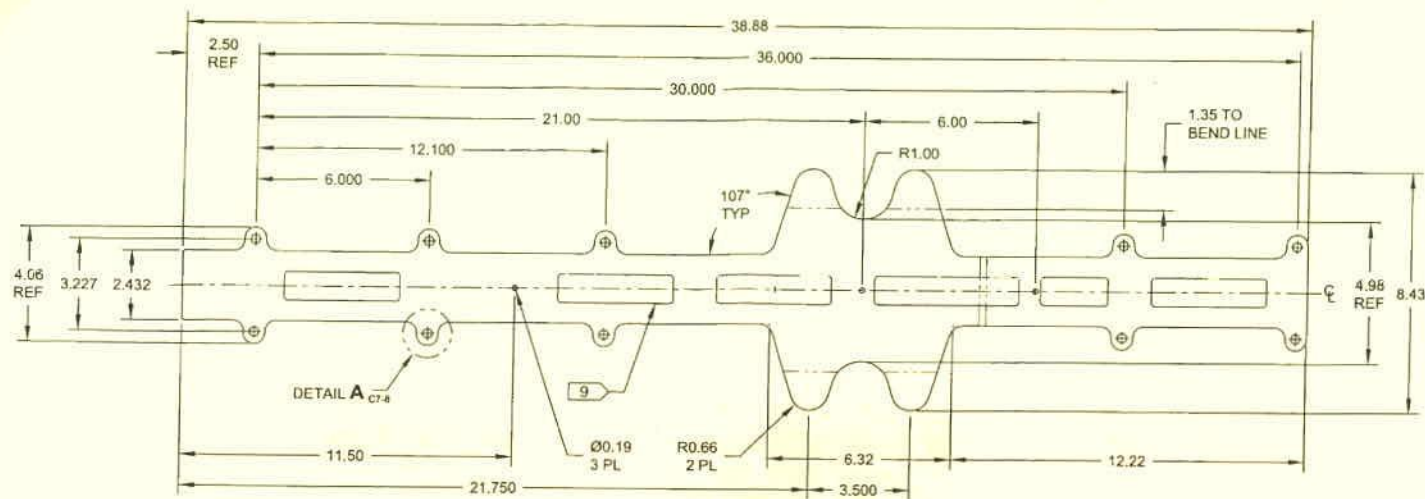
**DART AEROSPACE USA, INC**  
KENT, WA

DRAWING NO. REV. B  
D4095 SHEET 1 OF 8  
TITLE SCALE  
WEARPLATE NTS

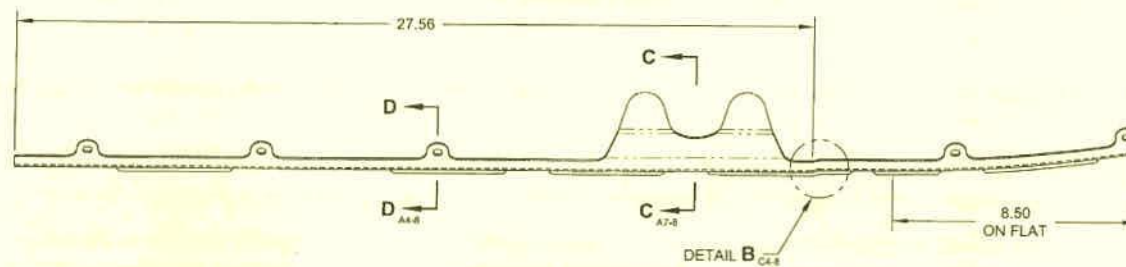
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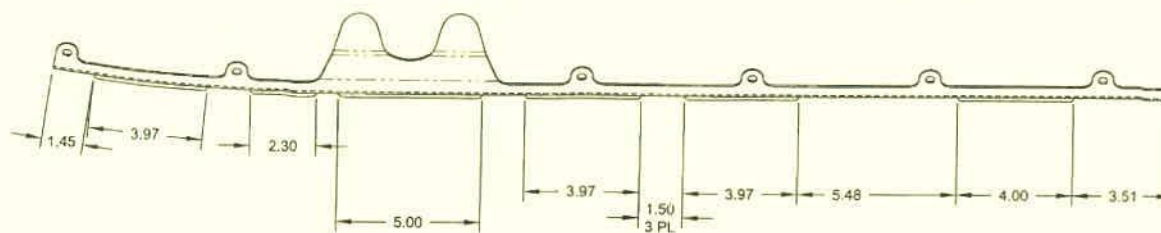
**D4095-3F FLAT PATTERN** 1



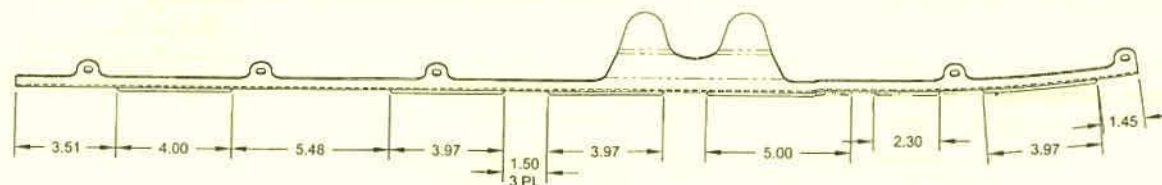
**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

RELEASE  
2011-10-31

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	NO	DRAWING NO.	REV. B
MFG. APPR.	NO	D4095	SHEET 4 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



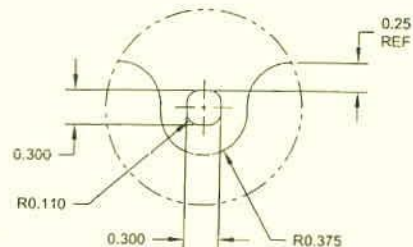
**D4095-1 WELDING DETAIL** B



**D4095-3 WELDING DETAIL** B

RELEASED  
2011-10-31  
M

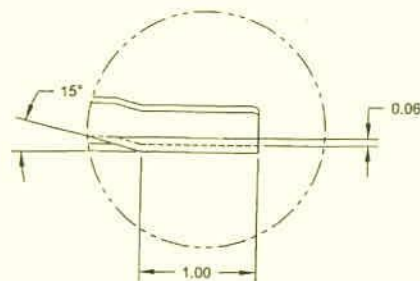
DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4095	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED UNDER THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINATION OF PURPOSES WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**DETAIL A: TAB DETAIL**

SCALE 4X

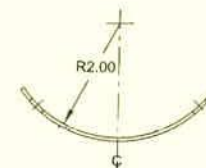
C3-3  
C6-4  
Q3-6  
Q2-7



**DETAIL B: JOGGLE DETAIL**

SCALE 4X

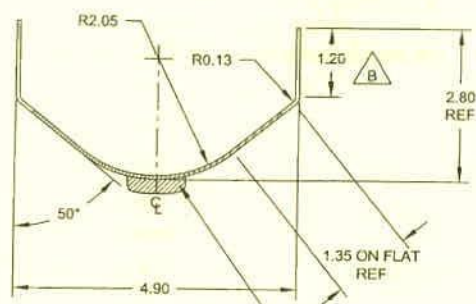
B2-3  
B6-3  
B3-4  
B2-6



**SECTION E-E**

SCALE 2X

B5-6  
B2-7

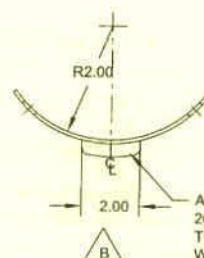


**SECTION C-C**

SCALE 2X

B5-3  
B4-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

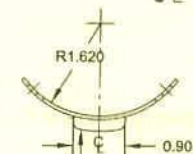


**SECTION D-D**

SCALE 2X

B4-3  
B5-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION F-F**

SCALE 2X

B5-7  
B7-7

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 8 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	<small>           COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS LOANED TO THE USER UNDER THE CONDITION THAT IT IS            NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.         </small>	

RELEASED  
2011-10-31  
NP



**T.P.I. INDUSTRIES INC.**

148 GOODFELLOW  
DELSON, QUÉBEC J5B 1V4  
CANADA  
Tel: (450) 633-0484  
Fax: (450) 633-0879

**Packing Slip**

Packing Slip No.: 6177  
Date: 2014-07-02  
Page: 1

<b>Sold to:</b>  Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	<b>Ship to:</b>  Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
<b>Order No.:</b> 24577	<b>Sold By:</b> JONATHAN LESSARD
<b>Shipped By:</b>	<b>Ship Date:</b> 2014-07-02
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	24
d3537-1	Chaque	d3537-1 wearpad	40
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	60
d2154	Chaque	d2154 bracket stud	20
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	40
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	12
d4952-1	Chaque	d4952-1 wearplate	16
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	20
d4095-047	Chaque	d4095-047 wearplate assy	16
d4798-041	Chaque	d4798-041 wearplate assy	20
d4135-1	Chaque	d4135-1 wearpad	16
d4360-041	Chaque	d4360-041 wearplate assy	10
d2012-111	Chaque	d2012-111 bracket	8
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	40
d3171-1	Chaque	d3171-1 angle bracket	60
d3463-3	Chaque	d3463-3 step	20
d3512-1	Chaque	d3512-1 wearplate	12
d3629-1	Chaque	d3629-1 bracket	16
d3955-5	Chaque	d3955-5 plate	20
d4021-5	Chaque	d4021-5 blanking plate	12
d3556-1	Chaque	d3556-1 clamp	40

**Comment:** Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days